

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011674**Date Inspected:** 23-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

This QA Inspector performed in process inspections in the trial assembly yard and monitored weld repairs in the heavy dock area to include the use of preheat, proper welding procedure, and the presence of ABF QA and ZPMC CWI's.

On this day, this Inspector was given Inspection Notification Sheet 004919. Items tested included floor beam FB204- 029- 069 inside OBG Cross Beam 11. The inspection was to ensure the removal of indications found during previous initial inspection. No recordable indication was observed.

On this date this Inspector was given ZPMC NDT Inspection Notification Sheet, Document No. 004917. The QA Inspector performed required Final Magnetic Particle and Visual Testing (MT/ VT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel, on the following items listed for final acceptance, (green tag), of the OBG sub-assemblies in Bay 9:

DP 3002-001- 10% Final MT/ VT Acceptable, Green Tag # 11834

DP 3005-001- 10% Final MT/ VT Acceptable, Green Tag # 11835

**Summary of Conversations:**

No relevant conversations.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Barrentine,Daniel
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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